



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-31702W19-11

Job Sheet 198236



Part No: RBE105-31702W19-11

Job Qty: 2 pcs

Part Name: Nut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/24/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE105-31702W19 Rev 2 IPP Rev. A 19.07.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	SL 454-1 SL2500	2 pcs	8/30/19	8/30/19	1.00	0.33	SL 454-1 SL2500		SL 19-8-24
110	QC 2	2 pcs	8/30/19	8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		SL
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		

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120 QC 8	2 pcs	8/30/19	0.00 0.00	QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	B - 19-08-25
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
130 Outsource - 13 - Zinc Plating	2 pcs	8/30/19		GRO002-VC	19-08-26
140 Packaging 2-1 - Receive - B4B	2 pcs	8/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	DP SEP 03 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
150 QC 6	2 pcs	8/30/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS 61 9-89
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				QC 6 - 40	
				QC 6 - 81	
160	Packaging 3-1 - Stock - B4B	2 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
170	QC 21 - SA	2 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

Part Op **100** - 1-Machine as per folio FC 931 FOLIO REV: AA DWG REV: 2 2-Deburr
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - -Issue P/O ; 44344 -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required
140 - Certificate of Conformity is required
150 - QC6- All purchased or subcontracted products
160 - Identify as per dwg & Stock Location:
170 - QC21- Final Inspection - Work Order Release

DAS 21 9-89 SEP 05 2019 GA134

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.125	AISI 4140 Quenched & Tempered Steel Round Bar 1.125" Dia.	.0666 ft (.0333 ea)	100-SL-154 - 1	5039966: -531

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	MT-4140QT-R1.125	0	17	0

Part Specifications	
Specifications could not be found.	

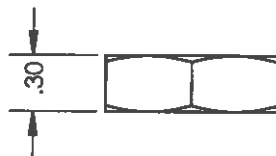
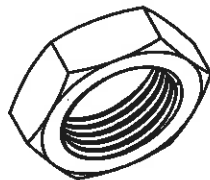
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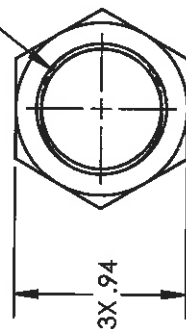
REV		ECR	REVISIONS	
2		16-0065	DESCRIPTION	DATE
			-11 CHD MATERIAL WAS HEX 4140 Q&T, IS 4140/4142 Q&T, CHD FINISH WAS CAD PLATE YELLOW IS ZINC PLATE, SPEC. ASTM B633 TYPE 1 SC2.	2/5/2016
				INITIAL
				APPROVED
				SM

SHOP COPY
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WITHOUT NOTICE

WORK ORDER
NO. 198216 MJS
1907-29



M18X2.0-6H



(-11)

NUT

DART
AEROSPACE

MOUNTING TOOL

DWG NO. RBE105-31702W19-11 REV 2

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± .8°
.X ± .1 SURFACES = 125/
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

DRAWN BY: SMITH
CHECKED: CLOUGH
QPPS APPR: ANDERSON
QA APPR: LINDSAY
APPROVED: MACKOVJAK
USED ON MODEL
EC145

SCALE 1:1 DATE 9/26/2013 SHEET 7 OF 11

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION		DEPARTMENT/PROCESS	
		Rework ☐ Scrap ☐ Use-as-is ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QS1042) _____	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
Other/Details: _____					
Completed By		Lead hand / Supervisor			
		QC / QA Coordinator			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044344



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044344

PO Date: 8/26/19

Due Date: 9/4/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-08-28

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198074	RBW6305G11731-3G-01	Body Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color; yellow -Material type; 1018 -Certificate of Conformity is required	Firmed -		9/4/19	6 pcs	0 pcs	6 pcs	\$15.00/pcs	\$90.00
				X6			5206519				DP
2	197596	RB T101880	Tool Sleeve Outsource13 (Outside Processing - Zinc Plating) -Issue P/O to GROUPE ALTECH: P/O _____ -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed -		9/4/19	1 pcs	0 pcs	1 pcs	\$4.7368/pcs	\$4.74
				X1			5198758				DP



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PURCHASE ORDER

POHB044344



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	198230	RBE105-31702W19-15	Handle Collet -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; Stress Proof -Certificate of Conformity is required	Firmed -		9/4/19	6 pcs	0 pcs	6 pcs	\$4.7368/pcs	\$28.42
				X6							DP
						SEP 03 2019					
											\$207109
4	198236	RBE105-31702W19-11	Nut -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed -		9/4/19	6 pcs	0 pcs	6 pcs	\$4.7368/pcs	\$28.42
				X6							DP
						SEP 03 2019					
											\$208518
											DAS 61 9-89
5	198239	RBE105-31702W19-9	Washer -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed -		9/4/19	6 pcs	0 pcs	6 pcs	\$4.7368/pcs	\$28.42
				X6							DP
						SEP 03 2019					
											\$207798
Grand Total:											\$180.00

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PURCHASE ORDER

POHB044344



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/28/19 9:13 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021886-2)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

021886 - 2

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
29-Aug-2019		SPARTAKOS BOUNTOURIS				POHB044344				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)		CATG. U/M	Comm. /Ordered	Exp/ Shipped	Quantités / Quantities Qté NC/ NC Qty		Qté Scrap/	À venir / Back Order
2	RB T101880 Rev.	RB T101880 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER B633 TYPE - 1, SC - 2 0.0003 "		ZINC CH	1	1	0	0	0	
3	RBE105-31702W19-15 Rev.	RBE105-31702W19-15 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER B633 TYPE - 1, SC - 2 0.0003 "		ZINC CH	6	6	0	0	0	
4	RBE105-31702W19-11 Rev.	RBE105-31702W19-11 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER B633 TYPE - 1, SC - 2 0.0003 "		ZINC CH	6	6	0	0	0	
5	RBE105-31702W19-9 Rev.	RBE105-31702W19-9 ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER B633 TYPE - 1, SC - 2 0.0003 "		ZINC CH	6	6	0	0	0	

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.

Euse